

Work Order ID 133633

133633

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June-30-15 3:08:55 PM

Item ID: MISC - Testing

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Eng Testing

Start Date: 6/12/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/12/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100 0.00

100

Crosstubes

Crosstubes

Memo

0.00

1. Pick D6021 - **M127271**
2. Machine to 2.3" OD x 6" Long
3. Grind surface smooth using GR80 drum belt and finish with a coarse BlendexTM drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.

1 0 0 **DAS 12 9-89** 15/5/20

110 0.00

110

Eng

Engineering

Memo

0.00

Engineering Approval

1 0 0 **DAS 12 9-89** 15/5/20

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Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 6/12/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
SprayPaint	Memo	0.00							
Spray Painting	6. Apply Axalta 13205S Aluminum Cleaner per manufacturer's instructions) M132473								
	7. Apply Axalta Metalok 230S Adhesion Promoter per manufacturer's instructions								
	8. Prime and paint outside of tube per Dart QSI 005 4.2								
130		0.00							
130									
Eng	Memo	0.00							
Engineering	Engineering Approval								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FOR TESTING
ONLY UP 15/6/30

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